



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2534

Job Sheet 188766



Part No: D2534

Job Qty: 10 pcs

Part Name: Lock Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/15/19

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A New Issue 05-11-07 JLM IPP Rev:B Now on Waterjet 06-06-20 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Flow - 1	10 pcs	1/31/19	1/31/19	0.00	0.42	Waterjet - Flow	OK 19/01/18
110	QC 2	10 pcs	1/31/19	1/31/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
120	QC 8	10 pcs	1/31/19	1/31/19	0.00	0.00	QC 8 - 12	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	DAS
				QC 8 - 38	38
				QC 8 - 39	9-89
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
130	Packaging 3-1 - Stock - B4B	10 pcs	1/31/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
140	QC 21 - SA	10 pcs	1/31/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
Part Op 100 - 1-Cut as per Dwg D2534 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check)					DAS 21 9-89 JAN 24 2019

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			

130 - (Identify as per dwg & Stock Location: _____) *****STOCK IN LARGE FAB***** LOCATION WA004
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	.4270 sf (.0427 ea)	100-Waterjet - Flow - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	0	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lock Plate	0.447inches + 0.006 - 0.001	0.453 0.446		
2	Lock Plate	0.500inches ± 0.010	0.510 0.490		
3	Lock Plate	0.173inches ± 0.010	0.183 0.163		
4	Lock Plate	0.096inches ± 0.010	0.106 0.086		
5	Lock Plate	0.125inches ± 0.010	0.135 0.115		
7	Lock Plate	0.200inches ± 0.010	0.210 0.190		
8	Lock Plate	0.125inches ± 0.010	0.135 0.115		

Plex 1/15/19 11:18 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐						
Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐																				
Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐																				
Date : _____		MRB (QSI042) _____																					
Description Wor _____		Completed By _____																					
DART Aerospace Ltd. 1270 Aberdeen Street Hewesbury, ON K64 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 01/18/19 Container No: S146047 Part: D2534 Job No: 188766 Serial No/Batch: S146047 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's		Lead hand / Supervisor _____																					
		QC / QA Coordinator _____																					
		<table style="width:100%;"> <tr> <td style="width:33%;"> Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ </td> <td style="width:33%;"> <table style="width:100%;"> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Broken/Damage/Detect</td> <td>☐ Weld</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> </tr> <tr> <td></td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> </tr> </table> </td> <td style="width:33%;"> <table style="width:100%;"> <tr><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Outside Tolerance</td></tr> <tr><td>☐ Drawing</td></tr> <tr><td>☐ Finish</td></tr> <tr><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Misread</td></tr> </table> </td> </tr> </table>			Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	<table style="width:100%;"> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Broken/Damage/Detect</td> <td>☐ Weld</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> </tr> <tr> <td></td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> </tr> </table>	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Broken/Damage/Detect	☐ Weld	☐ Marks/Chatter	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Mislabeled	☐ Drill Holes	☐ Out of Sequence		☐ Fit/Function	☐ Off-set/Set-up	<table style="width:100%;"> <tr><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Outside Tolerance</td></tr> <tr><td>☐ Drawing</td></tr> <tr><td>☐ Finish</td></tr> <tr><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Misread</td></tr> </table>	☐ Positioned Wrong	☐ Outside Tolerance	☐ Drawing	☐ Finish
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	<table style="width:100%;"> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Broken/Damage/Detect</td> <td>☐ Weld</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> </tr> <tr> <td></td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> </tr> </table>	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Broken/Damage/Detect	☐ Weld	☐ Marks/Chatter	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Mislabeled	☐ Drill Holes	☐ Out of Sequence		☐ Fit/Function	☐ Off-set/Set-up	<table style="width:100%;"> <tr><td>☐ Positioned Wrong</td></tr> <tr><td>☐ Outside Tolerance</td></tr> <tr><td>☐ Drawing</td></tr> <tr><td>☐ Finish</td></tr> <tr><td>☐ Part Lost/Missing</td></tr> <tr><td>☐ Misread</td></tr> </table>	☐ Positioned Wrong	☐ Outside Tolerance	☐ Drawing	☐ Finish	☐ Part Lost/Missing	☐ Misread			
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Broken/Damage/Detect	☐ Weld																					
☐ Marks/Chatter	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled																					
☐ Mislabeled	☐ Drill Holes	☐ Out of Sequence																					
	☐ Fit/Function	☐ Off-set/Set-up																					
☐ Positioned Wrong																							
☐ Outside Tolerance																							
☐ Drawing																							
☐ Finish																							
☐ Part Lost/Missing																							
☐ Misread																							
Other/Details: _____																							